Work Order ID 125903 -

Split -1 xax

^{*}125903*

Page 1

Friday, October	• 24, 2014 11	:12:01 AM										
Item ID:	D3490-3			Accept	*	V900	040	100)* ፡	Setup Sta	rt *N	S1*
Revision ID:					1,			,	-	' Sto	n Jal	001
Item Name:	Cross Bolt Sp	acer			2/W				•	Su	^ν *Ν	S2*
Start Date:	10/27/14	Start Qty: 220.0	o *タグ	A* 110		Cust Item 1	D:					,
Required Date:	: 11/28/14	Req'd Qty: 220.0	* * * * * * *	Ń *		Customer:						
Reference:									_			
Approvals:	Process Pla	ın:	Date: 14-10.2	└ Tooling:		D:	ate:]	Run Sta	^IVI	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:	· · ·	v'	Sto	» *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up Run H		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D3490	Rev	' A										
*100		Hardinge CNC LATHE	SMALL	0.00	DAS 40					• • • • • • • • • • • • • • • • • • • •		DAS 37 9-89 /4·/o·3
Hardinge		Memo		0.00	9-89							JFC 2014 11-2
Hardinge CNC Lath	ne Small	FOLIO RE DWG REV	S PER FOLIO FA629 & V:2 4/A R AS REQUIRED	DWG D3490	14/4/4							VIC 2011 (1-2
110		QC2- Inspect parts off	nachine FAI/FAÍB	0.00			•					DAS
110			1									37 9-89 <i>14-10</i> .
QC		Memo		0.00						-		
Quality Control		į										
120		QC8- Inspect parts - sec	cond check	0.00		. ·				_	1	
120		Memo	i,	0.00		T. B.				- Ju	//4.//.	2/ 110
Quality Control		Meino		0.00		•				/ /	/	

DQA:	QA: Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-((JINFOI	RIVIAINCE / C		Work Order up	odate only	AEROSPAC	Ē	
Work Orde	er:					DISPOSITION				AGAINST [DEPARTMENT	/PROCESS			
Part N	- lo					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor re/Packaging Supplier	Engineering Quality Other		
Root					Desci	ription of work order update	1	nitial	A	ction	Sign &				
Cause		Date	Step	Qty		or non-conformance	l	ief Eng		cription	Date	Verification	n QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
							FAL	JLT CAT	EGORY						
Landir	3 4	ear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning So	t strip in atter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/li ions Incomplete ned/off center led	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
-		urning Si Vave/Tw	•			Fit/Function		4	equence						

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Work Orde Friday, October				*125	903*				Page 2
Item ID: Revision ID:	D3490-3			Accept	*N900	04010)()* s	Setup Star	*NS1*
Item Name:	Cross Bolt S	расег						Stop	*NS2*
Start Date: Required Date: Reference:	10/27/14 : 11/28/14	Start Qty: 220.00 Req'd Qty: 220.00		220* 220*	Cust Item I Customer:	D:			
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:	R	Run Star	~I/JH1.
••			Date:	SPC (Y/N):	D:	ate:	_	Stop	*NR2*
Sequence ID/ Work Center II 124 *194*	D	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Cod	-	Reject Qty	Reject Insp. Number Stamp
HandFinish Hand Finishing		Memo CLEAN CRO	SSBOLT SPA	0.00 CER WITH ALUMINUM CLEANNE	ER				
126		QC5- Inspect part complete	eness to step o	n W/O 0.00			- (
126 QC Quality Control		Memo		0.00	·		T		4-11-25

130

Identify as per dwg & Stock Location: <u>LG</u> 00

130
Packaging

Memo

0.00

STOCK IN SKIDTUBE CELL Packaging

DQA:	A: Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER HOR			MVIAITOL / C	SIDAIL	W	ork Order up	date only	AEROSPACE	
Work Orde	er:					DIȘPOSITION		AGAINST DEPART					PROCESS		
Part N	No					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstub Small Fa Finishir Composit	b g		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
												J	'''		
Root			_	_	Descr	ription of work order update		Initial		ction		Sign &	-		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	QC Inspector	
Design Doc/Data	\dashv														
Equip/Tooling	\dashv														
Handling/Pre															
Material	\dashv								<u> </u>						
Operator	\dashv														
Offset/Setup	H														
Process															
Supplier	\Box														
Training	\Box								:						
Transport	Н					•	ļ								
Unapproved															
	<u> </u>			•			FA	ULT CA1	TEGORY			<u> </u>			
Landii	ng Ge	ar				General					·				
		ending				Bend		Folio/P	rogram		Г	Outside Dime	ensions	Pressure/Forced	
	C	entre No	t Concer	ntric		BOM/Route		Grain	J			Over/Under	tolerance	Set-up	
	Cı	acks				Broken/Damage/Defect		Hardwa	ire			Part Incorrec	-	Temperature/Cure	
	Cı	rimp/Kin	k/Ripple,	/Wave		Burrs		 Inspecti	ion Incomplete/l	Unqualified		Part Lost/Mi	_	Weld	
	Cı	uffs				Contamination		1	ions Incomplete			Part Moved	· -	Wrong Stock Pulled	
	Ci	rushing				Countersink		Misalig	ned/off center	•		Positioned W	ـــ rong/		
	Н	eat Trea	t			Cut Too Short		Mislabe				Power Loss/S	Surge [Other	
	In	spection	Strip in	Tube		Drawing		Misread	d			•	_		
	М	larks/Ch	atter			Drill Holes		Off-set							
	Τι	urning Se	equence			Finish		Out of 0	Calibration						
	[]w	/ave/Twi	ist in Tub	e		Fit/Function		Out of S	Sequence						

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Work Ord Friday, October				*125	5903*						Page 3
Item ID: Revision ID: Item Name:	D3490-3 Cross Bolt Spa	acer		Accept	*N900	04 0	100)*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	10/27/14 : 11/28/14	Start Qty: 220.00 Req'd Qty: 220.00	*220 *220		Cust Item I Customer:	D:					
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Insp. Number Stamp
140 QC Quality Control		Мето		0.00					_	14/	12/298) MF

DQA:			Date:		·	WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			Work or			JIII			/ork Order up	odate only	AEROSPACE
Work Orde	er:					DISPOS	SITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N	- No					Suspected Una	Rework Scrap Use-as-is approved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	ription of work o	rder update	I	nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or non-conform		Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														•
								FAL	JLT CAT	EGORY				
Landii		ear Bending Bentre No Bracks Brimp/Kin				General Bend BOM/Route Broken/Damage Burrs			Grain Hardwa	rogram re on Incomplete/U	Jngualified	Outside Dim Over/Under Part Incorred Part Lost/Mi	tolerance	Pressure/Forced Set-up Temperature/Cure Weld
		Cuffs Crushing Heat Trea				Contamination Countersink Cut Too Short	4	_	Instruct	ions Incomplete, ned/off center	/Unclear	Part Moved Positioned V Power Loss/	Vrong	Wrong Stock Pulled Other
		nspection	Strip in	Tube		Drawing	•		Misread	t	_			
	Ц١	∕larks/Ch	atter			Drill Holes			Off-set					
	-	urning Se Vave/Twi		e	-	Finish Fit/Function			1	Calibration Sequence	•			

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Picklist Print

Friday, October 24, 2014 11:12:05 AM

Work Order ID: 125903

125903

Parent Item:

D3490-3

D3490-3

Parent Item Name: Cross Bolt Spacer

Start Date: 10/27/14

Required Date: 11/28/14

Start Qty: 220.00

Required Qty: 220.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	53.4941	0.266	62		DAS	
*M6061T6	SR0 750	*							**			37	14.10.31

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code	
MAT012	53.494052		
m126852	3.494052		
m130043	2		
m130527	48		_30,4_

Page 1

DQA:		_ Date:			·							DART
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U		Work Order u	odate only	AEROSPACE
					DICOCCITION						<u> </u>	
Work Orde	er:				DISPOSITION				AGAINST	DEPARTMENT	/PROCESS _	
				_	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No				Scrap			Machining	Small Fab	—	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	NO				Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desci	ription of work order update	1	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design	56											
Doc/Data	5"5+"											
Equip/Tooling			-									
Handling/Pre												
Material												
Operator					·							
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved						<u> </u>						
						FAL	ULT CA	TEGORY				
Landii	ng Gear				General		1		Г		Г	_
	Bending			<u> </u>	Bend		1	Program	-	Outside Dim	 	Pressure/Forced
		ot Concei	ntric	<u> </u>	BOM/Route		Grain]	Over/Under		Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			Part Incorre	⊢	Temperature/Cure
•		nk/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Ui	- I	Part Lost/M	- -	Weld
	Cuffs			——	Contamination	igsqcup	1	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	-	1 -	ned/off center		Positioned \		
	Heat Tre		T b		Cut Too Short	-	Mislabe		Į	Power Loss/	Surge _	Other
	—	on Strip in	Tube	-	Drawing	\vdash	Misread			-		
	Marks/C			<u> </u>	Drill Holes	\vdash	Off-set					
		Sequence		-	Finish	\vdash	1	Calibration -				
	[Wave/Tv	vist in Tub	oe .		Fit/Function		Out of S	Sequence				

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DART AEROSPACE LTD	Work Order:	125903
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

FIRST ARTICLE INSPECTION CHECKLIST											
X First Article Prototype											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments				
3.085	+0.030/-0.000	3.095			DR 16	8"VER	.)				
0.080	+/-0.010	.075			11	11					
Ø0.591	+0.008/-0.001	.593			ų	40					
0.050 x 45°	+/-0.010 x 0.5°	.05×45°			15						
	· ·										
	DAS			1							
leasured by:	37 9-89	Audited by:	Chal		Prototype Ap	oproval:	N/A				
Date:	4.10.31	Date:	14.11.	24		Date:	N/A				

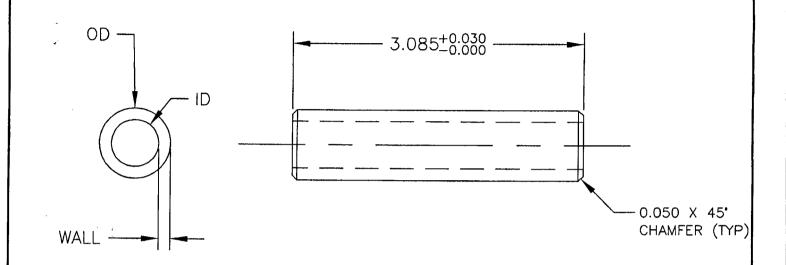
Rev	Date	Change	Revised by	Approvéd
L A	06.10.27	New Issue	KJ/JLM 🛠	
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DESIG	PH	DRAWN BY	DART		ROSPA PORT HAD			INC.
CHEC	KED #	APPROVED	DRAWING NO.				SH	REV. A EET 1 OF 1
DATE		·	TITLE		7.			SCALE
06.0	01.04	CROSS BOLT SPACER			NTS			
Α		06.01.04	NEW ISSU	JE				



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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